

# SPECIAL PACKAGING INSTRUCTION

CODE IT  
98747

SPI NO. (FED)  
F01-241-8951

SHEET 1 OF 2

PART OR DRAWING NO.

NATIONAL STOCK NO.

CURRENT  
REV

ILL P. ELLISON

080346-010

3040-01-241-8951

AI

B

CHK. G. INGLES

ENGR. P. FRANCEL

AUTH. A. BRIMMALL

ITEM NOMENCLATURE

ACTUATOR

ORIGINAL  
DATE  
88068

MILITARY PRESERVATION IAW MIL-STD-2073

PACKING AS SPECIFIED BELOW AND BILL OF MATERIALS

SERVICEABLE METHOD 10

UNSERVICEABLE METHOD 10

LEVEL SPEC STYLE TYPE CL VPLY IP

A

N/A

B ASTM D6256

A

1

1

A

QUP 001

EO 000

LEVEL A LEVEL B

CLEANING & DRYING IAW MIL-STD-2073

GROSS CU FT N/A 14.889

GROSS WT LBS N/A 80170

PRESERVATIVE N/A

DESIGN FRAGILITY G N/A 30

MARKING IAW MIL-STD-129

SPECIAL MARKINGS:

A) SPI NO F01-241-8951

MARK THE SPI NUMBER ON ONE SIDE OF THE CONTAINER

B) CAUTION: LIFT BY BASE ONLY  
C) TO OPEN REMOVE BOTTOM LAYS

LENGTH WIDTH DEPTH

CNTR ID 161 18 1/4 14

CNTR OD 163 20 1/4 14 1/4

ITEM DIM 155 1 1/4 14

ITEM WT LBS 8200

CAUTION:

IAW ASTM D6256

REVISION

CTR	DESCRIPTION	DATE
A	CHANGED SPEC CONTAINER	88068
B	COMPLETE UPDATE	90068

NOTE:

1. WRAP ACTUATOR IN WRAP REF 15 AND FASTEN WITH TAPE CONFORMING TO A-A-883 TYPE 1 or EQUAL

2. PLACE CHAFFING REF 16 OVER BUCKING REF 4 BETWEEN STRIPS REF 7 BEFORE SETTING ACTUATOR IN PLACE

3. SECURE ACTUATOR WITH STRAPS REF 8 AND BOLTS REF 10 MAKING SURE THAT CHAFFING STRIPS REF 17 ARE BETWEEN ACTUATOR AND STRAPPING

QTY	ITEM NO	DESCRIPTION	SIZE	PART NO	GRADE
17	4	CHAFFING STRIPS	24 X 3	PPP-P-115	TYPE 1 (or equal)
16	1	CHAFFING	115 X 18 1/2 X 1/8	PPP-C-1797	TYPE 1
15	1	WRAP	180 X 45	L P-378	TYPE 1, CLASS 1, GRADE A (IN 1)
14	32	WASHERS	1/4	FF-W-42	TYPE A, GRADE 1, CLASS 1
13	32	LAY BOLTS	1/4 X 2 1/2	FF-B-561	TYPE 1, ST. 316, GRADE 1
12	20	NUTS	3/8	FF-N-836	TYPE B, ST. 316
11	20	WASHERS	3/8	FF-W-42	TYPE A, GRADE 1, CLASS 1
10	8	BOLTS	3/8 X 15	FF-B-544	TYPE 1, CLASS 1, ST. 316
9	12	BOLTS	3/8 X 13	FF-B-544	TYPE 1, CLASS 1, ST. 316
8	4	STRAPS	6001 X 1 1/4 X 3/8	A-M-1-663	TYPE 1, HT 1000
7	4	STRAPS	4 X 4 (NOM) X 100 (1)	A-M-1-663	CLASS 1
6	4	STRAPS	4 X 4 (NOM) X 100 (1)	A-M-1-663	CLASS 1
5	4	STRAPS	4 X 4 (NOM) X 100 (1)	A-M-1-663	CLASS 1
4	14	STRAPS	4 X 4 (NOM) X 100 (1)	A-M-1-663	CLASS 1
3	4	STRAPS	4 X 4 (NOM) X 100 (1)	A-M-1-663	CLASS 1
2	4	STRAPS	4 X 4 (NOM) X 100 (1)	A-M-1-663	CLASS 1
1	4	STRAPS	4 X 4 (NOM) X 100 (1)	A-M-1-663	CLASS 1

FORM 100-100-100

FORM 100-100-100

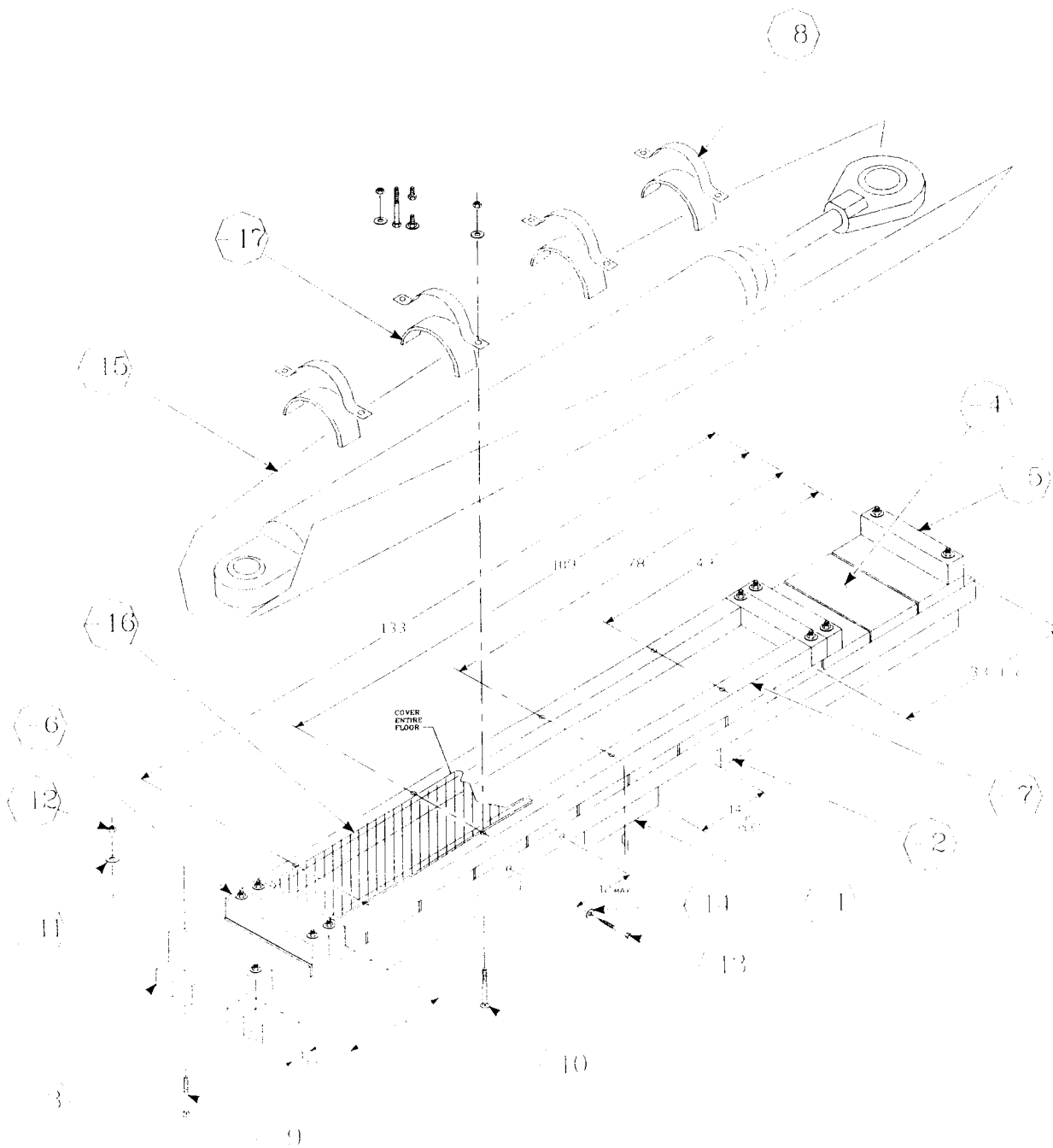
## SPECIAL PACKAGING INSTRUCTION

v. 43: 147

FOI 2041 330001

ITEM NOMENCLATURE  
ACTUATOR

SHELT &amp; DE





**DEPARTMENT OF THE AIR FORCE  
OGDEN AIR LOGISTICS CENTER (AFLC)  
HILL AFB, UTAH 84056-5609**

Date: 07 Mar 01

**WORK SPECIFICATION**

TYPE WORK: Essential Repair  
TYPE EQUIPMENT: LGM-118 Repairable  
End Item.

PRODUCTION MGR: Dorothy Olsen  
OFFICE/PHONE: LMBM/777-4242

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Prepared by: Bert Taylor

## **SECTION I GENERAL**

### 1.1 INFORMATION:

1.1.1 This Work Specification establishes the minimum work requirements for essential repair necessary to restore the LGM118 reparable end-items to a serviceable like new condition.

1.1.2 All work performed by the contractor will comply with the instructions and technical data requirements contained in this specification. Additional work discovered after award of contract that is not covered by the contract will be negotiated and approved by the CO through the ACO prior to work being started.

1.1.3 The contractor shall not design, develop or manufacture tooling or test equipment of a specialized nature as a requirement under this specification without the express direction of the CO through the ACO.

1.1.4 The contractor shall expend no effort under this work specification for additional engineering design or development of the end-items or components.

1.1.5 The functional capabilities for which the end-item was designed shall not be changed, modified, or altered unless such changes are directed by this work specification and authorized by the OO-ALC program manager.

### 1.2 TERMS EXPLAINED:

1.2.1 “Acceptance Test”: The functional and operational tests performed on the end-item to ensure that all performance standards are satisfactorily met to restore the end-item to a serviceable condition.

1.2.2 “ACO”: The Administrative Contracting Officer.

1.2.3 “Calibration”: A comparison between two instruments, one of which is a standard of higher accuracy, to detect and correlate or adjust any variation in the accuracy of the instrument or equipment item being compared or tested.

1.2.4 “CO”: The Contracting Officer.

1.2.5 “End-Item”: The item furnished to the contractor for maintenance.

1.2.6 “Essential Repair”: The minimal parts, labor, and processes required to restore an item to a serviceable condition.

1.2.7 “Government Approved Contractor Technical Data”: Contractor technical data that has been used in the manufacture/production for initial procurement of government end-items or any subsequent update/modification and can be used for the repair of such items.

1.2.8 “IAW”: In Accordance With.

1.2.9 “Inspection”: A thorough examination of an item to determine its identity and condition.

1.2.10 “Modification (MOD)”: A change in the physical or functional characteristics of a system, equipment or end-item that affects form, fit, or function.

1.2.11 “N/A”: Not Applicable.

1.2.12 “Production Management Specialist (PMS)”: That individual who develops and prepares the Contract Maintenance Purchase Request (PR) package, and is the program manager for the duration of the contract. PMS, as used in this document, refers to the production manager, office, and phone indicated on the title page of this Appendix A.

1.2.13 “Repairable”: An unserviceable item that can have maintenance performed to restore it to a serviceable condition.

1.2.14 “Reparable”: An unserviceable recoverable end-item that may or may not be repairable and refers more to its logistics status.

1.2.15 “Serviceable”: Capable of meeting the requirements and performing the function for which designed or modified and meets all test requirements established by this work specification and the technical data cited in Section IV.

1.2.16 “Technical Data”: All government and contractor drawings, specifications, standards, Technical Orders (T.O.s), technical manuals, and all other technical publications necessary to restore an item to a serviceable condition.

1.2.17 “Update”: To bring an end-item up to the latest acceptable government approved configuration without changing its original form, fit, or functional capability.

### 1.3 DATA:

1.3.1 Data/Reporting Requirements: See paragraph 3.2.7.

1.3.2 Technical Data: The removal, disassembly, inspection, essential repair, test, assembly, and reinstallation of component parts and equipment will conform to the instructions in this work specification and all applicable technical data/directives listed in Section IV.

1.4 SECURITY: DD Form 254 not required.

1.5 QUALITY: The inspection system requirements acceptable to the government, are specified in Schedule Section E of the contract/order.

1.6 CONDEMNATION AND REPAIR: It shall be considered uneconomical to accomplish repair on an end-item when the total cost for parts, material and labor exceeds 75% of the stock list price of a new item. Authorization to accomplish repair or condemnation shall be obtained through the ACO/CO from the program manager for end items determined to be uneconomical to return to a serviceable condition.

**NOTE:** If this requirement results in a firm fixed-price contract, the 75 percent criteria may be waived by the production manager for those items that the negotiated price exceeds the above criteria.

1.7 ROUTED REPAIR REPLACEMENT QUANTITIES (RRRQ): These are serviceable recoverable assets determined to be available and in long supply. RRRQ items shall not be repaired if available from the government, these items will be included on the rotatable spares attachment to an Appendix B, if applicable, and will be identified by an asterisk. The contractor shall contact the OO-ALC program manager for support of RRRQ items.

1.8 ACCESSORY AND COMPONENT REUSE, MAINTENANCE AND REPLACEMENT: Maintenance and replacement of accessory and component parts will be IAW specific work requirements listed in Section III of this work specification, the technical data cited in Section IV, and the appropriate government-approved contractor technical data.

1.9 SPECIAL TOOLS AND SUPPORT EQUIPMENT (ST/SE):

1.9.1 ST/SE necessary to accomplish maintenance and ensure serviceability of the end-item(s) will be identified in the appropriate technical data in Section IV; One each special test equipment will be provided by the Government.

1.9.2 Necessary ST/SE will be furnished by the contractor with the exception of a special test fixture provided to the contractor from the government. If substitute ST/SE are proposed for use in this effort, authorization must be obtained through the ACO/CO from the program manager.



**SECTION II  
RECEIPT OF EQUIPMENT AT FACILITY**

2.1 HANDLING: The contractor shall exercise care to prevent damage to Government Furnished Property/Equipment while in his possession.

2.1.1 The contractor shall store all Government Furnished Property in a secure area to provide protection against damage, pilferage, or loss. Storage areas shall provide protection against all adverse environmental conditions.

2.1.2 Reusable shipping containers, packaging, and crating material in which the Government Furnished Property is received shall be handled with care. Reusable containers shall be stored for reuse, and configuration of the containers shall not be altered.

2.2 INVENTORY INSPECTION: An inspection shall be performed on the end-item upon its receipt at the contractor's facility for the following:

2.2.1 Proper identity.

2.2.2 Damage.

2.2.3 Completeness.

2.2.4 Any deficiencies found as a result of the above inspection shall be brought to the attention of the ACO, and disposition shall be IAW instructions directed through the ACO and CO by the program manager.

2.3 PRESERVATION: While the end-items are in the possession of the contractor, they shall be handled and stored in such a manner to preclude damage by handling, weather or foreign matter.

### SECTION III WORK REQUIREMENTS

#### 3.1 GENERAL:

3.1.1 The contractor shall receive, disassemble, inspect, test, fault-isolate, and perform repair on each end-item and components, when applicable, to restore the items to a serviceable like new condition.

3.1.2 Parts or material used shall be equal to or exceed the original requirements of technical data cited herein. In the event deviation from the technical data is required, and the contractor desires use of a substitute part, an approval request in letter form will be submitted through the ACO/CO to the program manager who will obtain the appropriate engineering office approval.

3.1.3 Reworked component parts of the end-item shall meet serviceable criteria IAW technical data cited herein.

3.1.4 Serviceable precision matched or mated component parts shall be handled in a manner to ensure their reinstallation as a matched set.

3.1.5 Maintenance on the reparable end-items and components shall be accomplished using only current technical data.

3.1.6 If any applicable technical data is changed, revised, amended or supplemented after award of contract, and an increase or decrease in work requirements is involved, the ACO and CO will be informed. Any increase in labor and or materials will be accomplished by a revision to this work specification and other appendix packages as applicable and negotiated by the CO, prior to work being accomplished.

3.1.7 Reliability and Maintainability (R&M): Additional R&M is not required; however, existing R&M performance shall not be degraded during this work effort.

3.1.8 Environmental Stress Screening (ESS) Requirements: N/A.

3.1.9 Environmental Impact (EI) Requirements: N/A.

3.1.10 Electrostatic Discharge Control: N/A

#### 3.2 SPECIFIC WORK REQUIREMENTS:

**NOTE:** Government approved contractor technical data shall be used to accomplish the specific work requirements in paragraphs 3.2.1 through 3.2.8. Contractor data will be supplemented as applicable by the general technical data cited herein and listed in Section IV.

3.2.1 Disassembly: The contractor shall disassemble each item only to the extent necessary to accomplish inspection, testing, fault isolation and determine required repairs.

3.2.1.1 Upon completion of tasks in Paragraph 3.2.1, repair requirements shall be negotiated with the ACO and approved by the PCO prior to work being started.

3.2.2 Cleaning: The contractor shall clean the end-items thoroughly prior to and after disassembly and maintain cleanliness during this maintenance effort IAW T.O. 1-1-691C and contractor practices.

3.2.3 Inspection:

3.2.3.1 The contractor shall accomplish a thorough inspection of each end-item, reusable or replacement component parts and materials (external and internal) for the following:

3.2.3.1.1 End-item for loose or missing parts, materials and attaching hardware.

3.2.3.1.2 End-item for dents, punctures, bent pins, cracks, wrinkled or misaligned conditions that may cause chafing.

3.2.3.1.3 Component parts, material, and attaching hardware to determine serviceability and conformance with the technical data.

3.2.3.1.4 Structural parts for dents, punctures, cracks, oversized holes, evidence of chafing, and corrosion IAW MIL-STD-1949.

3.2.3.2 Non-Destructive Inspection (NDI): N/A.

3.2.3.3 The contractor shall accomplish inspections during the maintenance process while the item is accessible for the following:

3.2.3.3.1 Quality repair of replacement parts when accomplished.

3.2.3.3.2 Correct dimensions of repair or replacement parts.

3.2.3.3.3 Correct type and quantity of parts and materials.

3.2.3.3.4 Check for insulation between dissimilar metals.

3.2.3.3.5 Check for unauthorized or unacceptable maintenance.

**NOTE:** If unauthorized or unacceptable maintenance is suspected or verified, notify the OO-ALC program manager through ACO/CO.

3.2.4 Corrosion Control and Treatment: Accomplish corrosion control and treatment as required, using methods and materials IAW T.O. 1-1-691C and contractor practices.

3.2.5 Maintenance: The contractor shall perform the required maintenance, inspection, and reassembly of the reworked end-item and components and calibrate, if applicable, IAW T.O. 00-25-234. Ozone depleting chemicals for use as flux removal solvent shall not be used for this repair. Suggested substitutes for flux removal solvents are isopropyl alcohol or acetone, or other effective non-ODC or non-EPA-17 chemicals compatible with the substrate.

3.2.5.1 In all applications before substituting a non-ODC chemical when government documents call for ODC usage, approval must be obtained from the government ODC Engineer through the PCO to insure compatibility of the new process with the affected surfaces.

3.2.5.2 Without specific approval from the government ODC Project Engineer through the PCO, the contractor shall not introduce a new component or process through this contractual activity which requires the government to newly use an ODC or an EPA-17 chemical in normal use, maintenance, or repair actions.

3.2.5.3 The contractor shall perform an acceptance test IAW T.O. 21-LG118A-22-8-1-1 or PD4600014-010 (CAGE 04236) of each completed end-item to assure serviceability prior to presentation to the government. Each end-item shall be extended, measured and adjusted to the required length IAW 080346-010 (CAGE 11132).

3.2.5.4 Upon satisfactory completion of final test, the contractor shall cover and seal all ports, vents and electrical connections/plugs with suitable caps to prevent entry of foreign matter or damage during handling and shipment.

3.2.6 Finishing:

3.2.6.1 The contractor shall repair or replace damaged internal protective finish to the extent necessary to ensure serviceability and provide protection during use.

3.2.6.2 External finishing of the end-item shall be painted using the following:  
a-Primer, MIL-P-2337, b-Topcoating, MIL-C-83286, c- Color, FED-STD-595, color No. 17875 white, IAW 080346-010 (CAGE 11132).

3.2.6.4 The contractor shall replace damaged marking, identification and decals IAW para 4.5..

3.2.6.5 Each completed end-item will be permanently and legibly marked with the contractor's facility identification. This identification will display the name of the contractor facility, date of maintenance and contract number. This identification can be by decalcomania, rubber stamp, or stencil. When using rubber stamp or stencil, use permanent, waterproof ink or paint of contrasting color; also, end-item identification plates shall reflect the latest modification/update, i.e., National Stock Number, Part Number, etc., as applicable.

3.2.7 Deliverable Data Requirements: The contractor shall provide copies of DD Form 250, IAW the general provision of the contract.

3.2.7.1 Materials Identification and Usage: When government specifications/procurement documents direct the use of specific Ozone Depleting Substances (ODCs) or EPA-17 chemicals in contractor processes, quantify those processes, chemicals and quantities used and report IAW A001. This does not apply to chemicals used at the contractor's discretion which are not mandated by government requirements.

3.2.8 Government Acceptance Inspection: All work will be subject to government acceptance inspection and shall conform to this work specification, the technical orders and other applicable directives listed in Section IV.

## SECTION IV TECHNICAL ORDERS (T.O.s) AND OTHER DIRECTIVES

**4.1 TECHNICAL DATA REQUIREMENTS:** The contractor shall maintain all T.O.s applicable to this work requirement in a current status IAW T.O. 005-1, distribution IAW T.O. 005-2. The contractor shall comply with the latest dated T.O.s and other directives used or issued during the time the work is being accomplished and perform a timely review of all updated T.O.s and other directive changes applicable to the work requirement. The review will consider the impact on work requirements, cost, and schedules with backup data for those changes. Increases or decreases in work, which impact the maintenance facility or the government, will be sent through the ACO to the CO for negotiation and approval prior to beginning work.

### **4.2 APPLICABLE TECHNICAL ORDERS:**

**NOTE:** The contractor shall not use any Class I Ozone Depleting Chemicals (ODCs) specified in the following references or compliance documents during the course of this contract. If a substitute for ODCs is not available and ODCs are proposed for use in this effort authorization must be obtained through the ACO/CO from the program manager.

#### **4.2.1 General (As applicable):**

T.O. 00-5-1     AF Technical Order System  
T.O. 00-5-2     AF Technical Order Distribution System

#### **4.2.2 Specific (Compliance T.O.s):**

T.O. 21-LG118A-22-8-1-1     Depot Level Operations and Maintenance Control,  
Test Parameters  
T.O. 21-LG118A-22-8-1     Depot Operation and Maintenance Manual,  
Transportation and Handling Equipment

### **4.3 APPLICABLE TIME COMPLIANCE TECHNICAL ORDERS: N/A**

### **4.4 APPLICABLE REFERENCES:**

MIL-STD-1949	Magnetic Particle Inspection
FED-STD-595	Federal Standard Colors
MIL-C-83286	Coating, Polyurethane, High Solids
MIL-P-23377	Primer Coatings

#### 4.5 APPLICABLE CONTRACTOR TECHNICAL DATA:

Document Identifier	Government Approved Contractor Technical Data
Source Control Drawings	(CAGE: 04236) PD4600014-010 (CAGE: 11132) 080346-010

Technical orders/manuals, technical directives and other applicable publications required to accomplish the work effort, but not in possession of the contractor, shall be acquired as authorized by the ACO.

**NOTE:** Primary source for military specifications and standards is:

DODSSP  
Building No. 4/ Section D  
700 Robbins Ave  
Philadelphia, PA 19111-5094

DSN 88-442-2179/2667 Website <http://www.dodssp.daps.mil/>

HEADQUARTERS  
OGDEN AIR LOGISTICS CENTER  
UNITED STATES AIR FORCE  
HILL AIR FORCE BASE, UTAH 84056

APPENDIX "C"

DATE:

AF CONTRACT NR

SAFETY INFORMATION

TYPE WORK: ESSENTIAL REPAIR

TYPE EQUIPMENT: LGM-118 REPARABLE END ITEMS

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PREPARED BY: SEG/GOODSELL/71428/01-033

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SECTION 1 - INDUSTRIAL SAFETY REQUIREMENTS

1.1 General Requirements:

1.1.1 The contractor shall protect government property to prevent damage during the period of time the property is under the control or possession of the contractor.

1.1.2 The contractor shall include a clause in all subcontracts to require subcontractors to comply with the safety provision of this contract.

1.1.3 The contractor shall ensure that the safety designed into the system is not degraded by the repair methods or procedures, or changes initiated during work processes associated with this contract.

1.1.4 The contractor shall comply with all safety provisions, e.g. technical specifications, technical publications, etc., referenced in the work requirements of this contract.

1.1.5 Accident/Incident Reporting and Investigation:

1.1.5.1 The contractor shall report promptly to the Administrative Contracting Officer (ACO) all available facts relating to each instance of damage to government property.

1.1.5.2 When a major mishap (\$10,000 or more) involving government property occurs, the contractor shall immediately secure the accident scene and damaged item or wreckage until released by the accident investigative authority as designated by the contracting ALC Safety Office. Such release will be accomplished through the ACO.

1.1.5.3 If the government elects to conduct an investigation of the accident, the contractor shall cooperate fully and assist government personnel until the investigation is completed.

1.1.5.4 The contractor shall include a clause in each of his applicable subcontracts to require subcontractor's cooperation and assistance in accident reporting and investigation.

1.2 Specific Requirements:

1.2.1 Storage of government property shall be provided in accordance with DOD Regulation 4145.19-R-1, paragraphs 6-107, 6-108, 6-109a, 6-110, 6-117, 6-121 and 6-122.

1.2.2 Inspect and maintain hoists, cranes, slings, and other lifting equipment to ensure safe operation:

1.2.2.1 All lifting devices and equipment shall have sufficient capacity for the loads lifted.

1.2.2.2 All lifting devices and equipment shall be labeled to indicate their load capacity.

1.2.2.3 All lifting devices and equipment shall be visually inspected for damage or defects each day before being used.

1.2.3 Welding of aircraft or aerospace equipment will be in accordance with AFOSH Standard 91-5.

1.2.4 The storage and use of paint and dope materials in the vicinity of government property shall be in accordance with the applicable parts of National Fire Protection Association (NFPA) 33.

1.2.5 Flammable liquids in the vicinity of government property shall be handled and stored in accordance with the applicable parts of NFPA 30.

1.2.6 Flammable gas cylinders in the vicinity of government property shall be handled and stored in accordance with the applicable parts of NFPA 51.

1.2.7 Adequate portable or fixed fire extinguishing equipment shall be conspicuously located and readily accessible for immediate use in the event of fire.

## SECTION 2 BIBLIOGRAPHY OF PUBLICATIONS/DIRECTIVES:

The documents listed herein are applicable to the extent required by other provisions of Sections 1. The listed documents of the issue in effect on date of invitation for bid or request for proposal, form a part of the specification to the extent specified herein.

NATIONAL FIRE PROTECTION ASSOCIATION (NFPA) 30	Flammable and Combustible Liquids Code
NFPA 33	Spray Application Using Flammable and Combustible Materials
NFPA 51	Oxygen-Fuel Gas Systems for Welding, Cutting and Allied Processes
AFOSH STD 91-5	Welding, Cutting and Brazing
DOD Manual 4145.19-R-1	Storage and Materials Handling

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FD2020-01-20112